

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010911**Date Inspected:** 14-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

Bay 10

This QA Inspector randomly observed the following work in progress in Bay 10:

FCAW repair welding of weld joint SSTL4-1B/L-3B located inside PCMK south tower, lift 4,skin A to skin E at approximately the 126M elevation. Welder was identified as 040343. ZPMC QC was identified as CWI Wang Chuan Qing (QC1). Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Wang Hao, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-FCAW-2G(2F)-repair as listed on the unnumbered ZPMC weld repair report presented to this QA Inspector by QC Wang Hao.

FCAW repair welding of weld joint SSTL4-1B/L-5B located inside PCMK south tower, lift 4,skin B to skin C. Welder was identified as 053869. ZPMC QC was identified as QC1. Assisting QC1 at this location and appearing to be monitoring the welding and recording data was ZPMC Wang Hao, who was not a CWI. The welding variables recorded by QC1's assistant appeared to comply with WPS-345-FCAW-2G(2F)-repair as listed on the unnumbered ZPMC weld repair report presented to this QA Inspector by QC Wang Hao.

FCAW welding of weld joint NSTL4-3C/L-31 located inside PCMK north tower, lift 4,skin E stiffener to 119M double diaphragm web. Welder was identified as 052930. ZPMC QC was identified as QC1. The welding

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variables recorded by QC1 appeared to comply with WPS-B-T-3312-TC-P4.

FCAW welding of weld joint NSTL4-3F/L-23 located inside PCMK north tower, lift 4, skin E stiffener to 127M double diaphragm web. Welder was identified as 057259. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-3312-TC-P4.

FCAW welding of weld joint NSTL4-3H/L-8 located inside PCMK north tower, lift 4, skin E stiffener to 131M double diaphragm web. Welder was identified as 040490. ZPMC QC was identified as QC1. The welding variables recorded by QC1 appeared to comply with WPS-B-T-3312-TC-P4.

SAW welding of weld joint NSTL4-3B/L-5A located outside PCMK north tower, lift 4, skin B to skin C, between approximately 122.5M and 125M elevation. Welder was identified as 051413. ZPMC QC was identified as CWI Tu Jun (QC2). Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Gao Zhi Chun, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also at this location and appearing to be monitoring the welding operation were ABF Representative Li Nan.

SAW welding of weld joint NSTL4-3B/L-5A located outside PCMK north tower, lift 4, skin B to skin C, between approximately 125M and 129M elevation. Welder was identified as 0503060. ZPMC QC was identified as QC2. Assisting QC2 at this location and appearing to be monitoring the welding and recording data was ZPMC Gao Zhi Chun, who was not a CWI. The welding variables recorded by QC2's assistant appeared to comply with WPS-B-T-2221-C-U2b-S-2. Also at this location and appearing to be monitoring the welding operation were ABF Representative Li Nan.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet, George	Quality Assurance Inspector
Reviewed By:	Dawson, Paul	QA Reviewer
